

Work Order ID 142033-2 Split 1/1

Wednesday, March 09, 2016 10:38:40 AM

142033

Page 1

Item ID: D5378-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Bearpaw Wearplate Assembly

Start Date: 3/16/2016 Start Qty: 16.00

16

12

Cust Item ID:

Required Date: 3/28/2016 Req'd Qty: 16.00

16

Customer:

Reference:

Approvals: Process Plan: MJS

Date: MAR 09 2016 Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D5378	A
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100

0.00

100

Waterjet

Memo

0.10

FLOW CNC Waterjet

1-Cut as per Dwg. (D5378-1)

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

16

03/16/03/14

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

16

03/16/03/14

Wednesday, March 09, 2016 10:38:40 AM

Page 2

Accept

Setup Start

NS1

Stop

NS2

Cust Item ID:

Start Date: 3/16/2016 Start Qty: 16.00

16

Customer:

Required Date: 3/28/2016 Req'd Qty: 16.00

16

Reference:

Approvals: _____ Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

[illegible]

Work Order ID 142033

142033

Page 3

Wednesday, March 09, 2016 10:38:41 AM

Item ID: D5378-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Bearpaw Wearplate Assembly

Start Date: 3/16/2016 Start Qty: 16.00

16

Cust Item ID:

Required Date: 3/28/2016 Req'd Qty: 16.00

16

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

NR1

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC9- Inspect visual per OSI004- Fusion Welds	0.00							
150									
QC	Memo	0.00							
Quality Control									
160	Identify as per dwg & Stock Location: <u>St</u>	0.00							
160									
Packaging	Memo	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.03							
Quality Control									

DAS
9
9-89

12 16-03-21

12

DAS
6
9-89

MAR 22 2016

MCS

MAR 22 2016

MCS

MAR 22 2016

Wednesday, March 09, 2016 10:38:43 AM

Work Order ID: 142033

1420.33

Parent Item: D5378-041

D5378-041

Parent Item Name: Bearpaw Wearplate Assembly

Start Date: 3/16/2016

Required Date: 3/28/2016

Start Qty: 16.00

Required Qty: 16.00

Comments: IPP REV:A 15.12.18 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4379-1		Manufactured	No				Each	80.0000		96			
D4379-1									**			16-03-16	
Wearplate Cup													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA002	142436			80		80			
					140673			40		16			
					141338			40					
D4379-7		Manufactured	No				Each	4.0000		64			
D4379-7									**			16-03-16	
Wearplate Cup													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				prelim	142038			4		60			
					140627			4		4			
M304S16GA		Purchased	No				sf	167.1090		16			
M304S16GA									**			16-03-14	
304/316 Sheet .063													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				MAT019				167.109					
					m134067			8.006					
					m134158			95.103		17.3			
					m134399			64					

DART AEROSPACE LTD	Work Order:	142 033
Description: <i>Bearpaw Wearplate Ass</i>	Part Number:	125378-041
Inspection Dwg <i>05378</i> Rev: <i>A</i>	Page 1 of 1	

INSPECTION SHEET

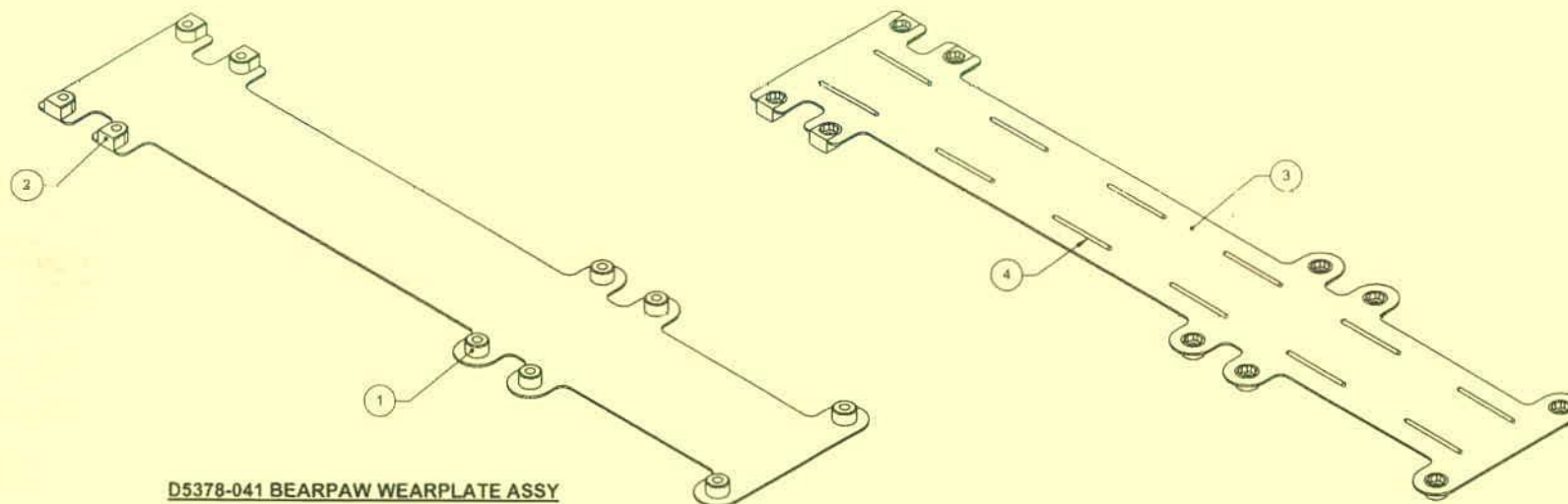
[illegible]

Measured by:	Checked by:	QC Inspector:
Date: 16/03/19	Date: MAR 14 2016	Date:

Engineering Approval: (If necessary)		Date	
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Rev	Date	Change	Revised by	Approved
B	14 07 31	New Issue	KJ	

ITEM	QTY	P/N	DESCRIPTION
	X	D5378-041	BEARPAW WEARPLATE ASSY
1	6	D4379-1	WEARPLATE CUP
2	4	D4379-7	WEARPLATE CUP
3	1	D5378-1	WEARPLATE
4	A/R	8259 \ 2059B	HARD SURFACING



D5378-041 BEARPAW WEARPLATE ASSY

NOTES:

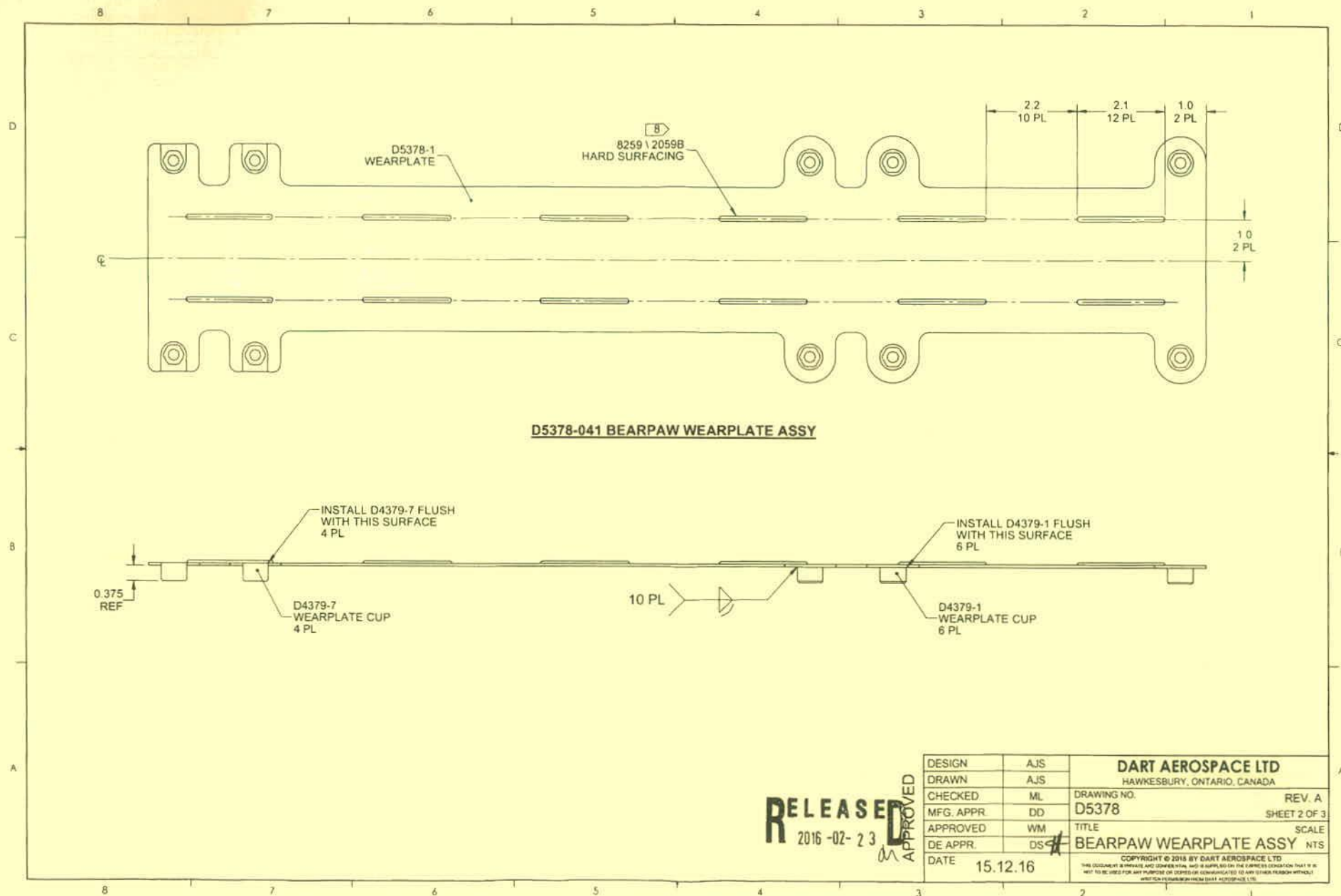
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 2.17 lbs
- 8) BUILDUP HARD SURFACING 0.06 - 0.13 THICK USING 8259 ROD PER QSI 004 SECTION 4.5 (AUTOMATED WELDING) OR BUILDUP HARD SURFACING 0.06 - 0.13 THICK USING 2059B ROD PER QSI 004 SECTION 4.1 (MANUAL WELDING)

RELEASED
2016-02-23
BN 16-527

APPROVED

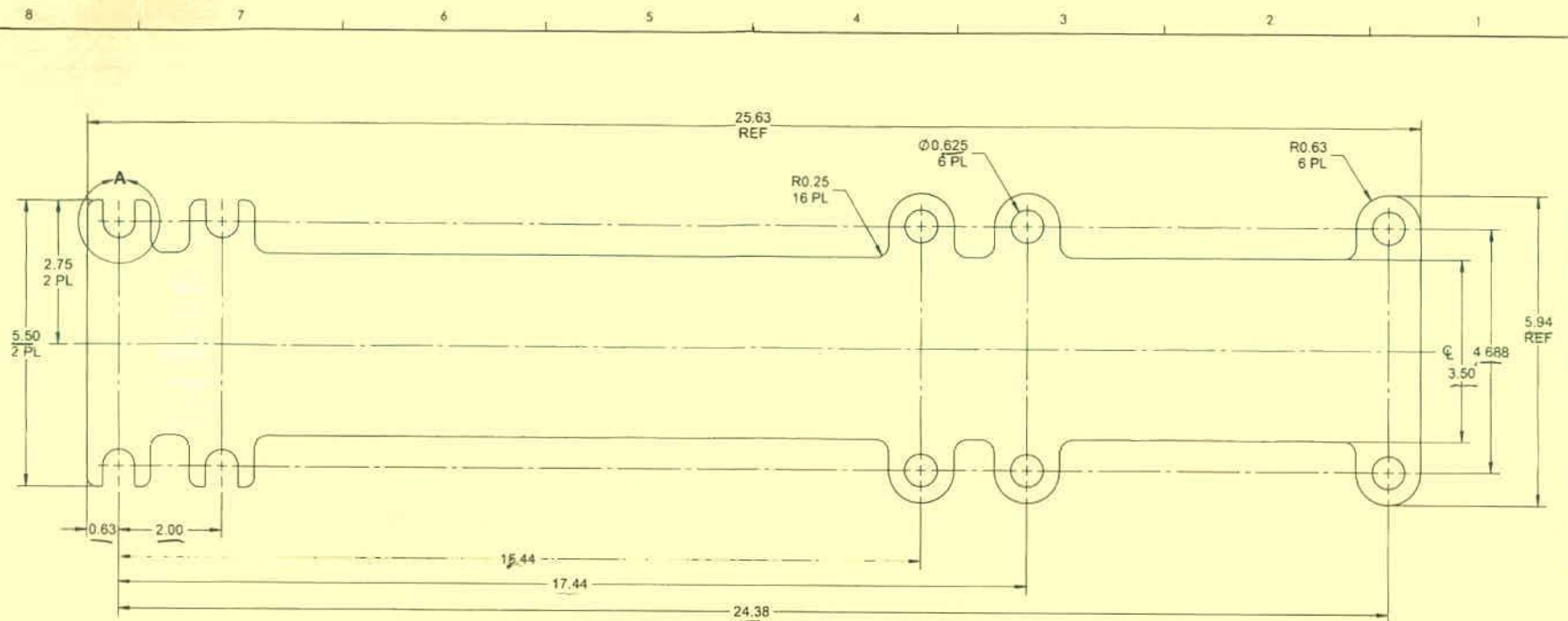
A		NEW ISSUE		AJS	15.12.16
REV	DESCRIPTION			BY	DATE
DESIGN	AJS			DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D5378 REV. A SHEET 1 OF 3 TITLE BEARPAW WEARPLATE ASSY SCALE NTS	
DRAWN	AJS				
CHECKED	ML				
MFG. APPR.	DD				
APPROVED	WM			DATE 15.12.16	
DE APPR.	DS				

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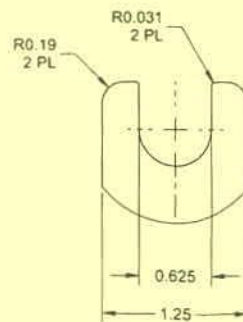


RELEASED
2016-02-23

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	ML	DRAWING NO. D5378	REV. A
MFG. APPR.	DD	SHEET 2 OF 3	
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	BEARPAW WEARPLATE ASSY	NTS
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D5378-1 WEARPLATE



**DETAIL A
(TAB DETAIL)
4 PL
SCALE 2X**

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET ANNEALED, 0.063 THICK
PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316)
OR ASTM A240 OR ASME SA240
REF DART SPEC M304S
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.78 lbs

RELEASED
2016-02-23
EEN 4519

APPROVED

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ML	DRAWING NO.	REV. A
MFG. APPR.	DO	D5378	SHEET 3 OF 3
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	BEARPAW WEARPLATE ASSY	
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